

# Work Order ID 52705

October 8, 2009 10:20:11 AM



Page 1

Item ID: D212-725-1-145

Accept



Setup Start



Revision ID: D

Stop



Item Name: Tube

Start Date: 10/08/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/21/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 09/10/08 Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

|            |   |
|------------|---|
| D212-725-1 | D |
|------------|---|

100

0.00



Small Fab

Memo

0.00

cut as per dwg D212-725-1

*Mrh 09/10/15*

*(10X)*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*2801/15*

*(10)*

130

Identify as per dwg & Stock Location: 360

0.00



Packaging

Memo

0.00

Packaging

*9/10/16 (10) SP*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 52705**

October 8, 2009 10:20:11 AM

Page 2

Item ID: D212-725-1-145

Accept

Revision ID: D

Item Name: Tube

Setup Start

Stop

Start Date: 10/08/09 Start Qty: 10.00

Required Date: 10/21/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19 *[Signature]*

MF 09-10-19

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

October 8, 2009 10:20:11 AM

Page 1

Work Order ID: 52705

Parent Item: D212-725-1-145

Parent Item Name: Tube

Comments:

Start Date: 10/08/09

Required Date: 10/21/09

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304TR1.500W.049                |                        | Purchased     | No          |                     |                  |                 | f                  | 12.4000        | 2.1053                   |               |                |        |
| 304 RD Tube 1.50 x .049W        |                        |               |             |                     |                  |                 |                    |                |                          |               |                |        |

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u>  |                |                 |
| Main Warehouse   |                |                 |
| MAT              | 12.4           |                 |
| 107000 ✓         | 12.4           |                 |

M-h 09/10/13

M 107000

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

SHOP COPY

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SUBJECT TO AMENDMENT

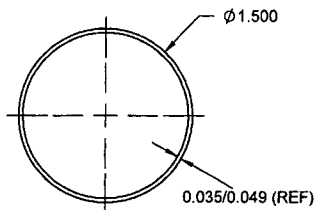
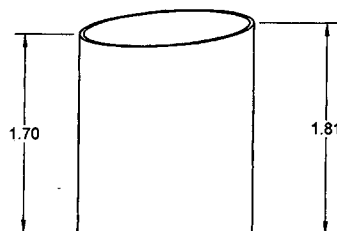
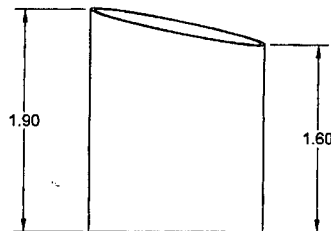
WITHOUT NOTICE

WORK ORDER

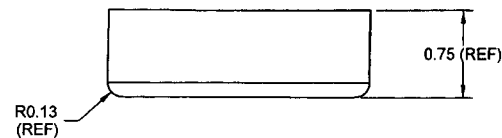
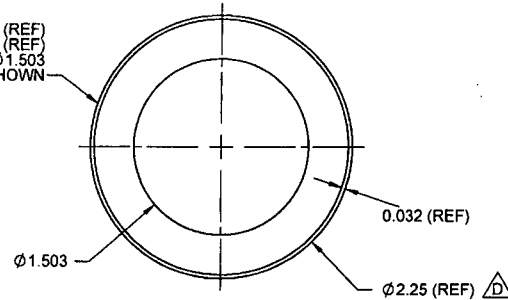
NO. 52705

0209/10/08

BELL P/N 204-060-767-001 (REF)  
OR 204-060-741-001 (REF)  
OPEN TO  $\phi 1.503$   
AS SHOWN



**D212-725-1-145 TUBE**



**D212-725-1-147 TUBE**

**D212-725-1-145 NOTES:**

- 1) MATERIAL: AISI 304/316 SS  $\phi 1.500 \times 0.049/0.035$  WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR1.500W.049/035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

|            |          |  |                |
|------------|----------|--|----------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b>  |                |
| DRAWN      | RF       | HAWKESBURY, ONTARIO, CANADA  |                |
| CHECKED    | DS       | DRAWING NO.  | REV. D         |
| MFG. APPR. | N/A      | <b>D212-725-1</b>  | SHEET 48 OF 67 |
| APPROVED   | #        | TITLE  | SCALE          |
| DE APPR.   | #        | <b>212S DETAIL PARTS</b>   | 1:1            |
| DATE       | 08.03.14 | <small>COPYRIGHT © 2006 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |                |

RELEASED  
08070314

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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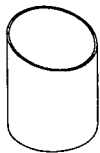
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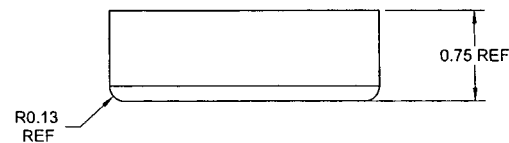
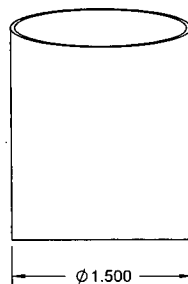
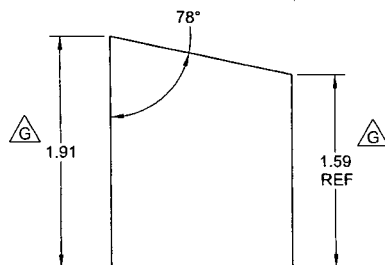
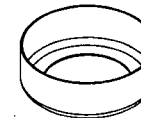
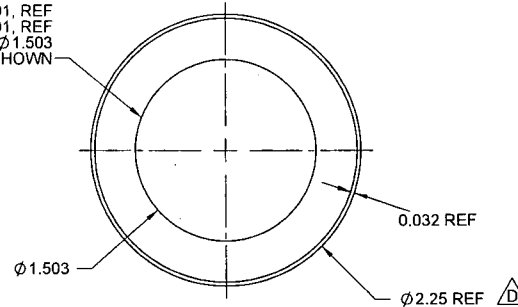
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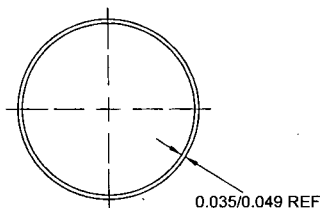
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BELL P/N 204-060-767-001, REF  
OR 204-060-741-001, REF  
OPEN TO  $\phi 1.503$   
AS SHOWN



**D212-725-1-147 TUBE**



**D212-725-1-145 TUBE**

REFERENCE ONLY  
REFERENCE ONLY

52705

PRELIMINARY

**D212-725-1-145 NOTES:**

- 1) MATERIAL: AISI 304/316 SS  $\phi 1.500 \times 0.049/0.035$  WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR1.500W.049/.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

|            |          |  |                |
|------------|----------|--|----------------|
| DESIGN     | RF       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |                |
| DRAWN      | RF       |  |                |
| CHECKED    | DS       | DRAWING NO.<br><b>D212-725-1</b>   | REV. G         |
| MFG. APPR. |          | TITLE<br><b>212S DETAIL PARTS</b>  | SHEET 48 OF 86 |
| APPROVED   |          | SCALE<br>NTS   |                |
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| DATE       | 09.10.14 |  |                |

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1

**L Lacelle**

**From:** Roberto Fuentes [rfuentes@dartaero.com]  
**Sent:** October 14, 2009 11:22 AM  
**To:** Linda Lacelle  
**Subject:** FW: Throttle feed through

Please, let me know if want it. They got 20 ft.

Roberto

---

**From:** Colin Gould [mailto:cgould@eaglecopters.com]  
**Sent:** Wednesday, October 14, 2009 9:01 AM  
**To:** Roberto Fuentes  
**Subject:** Throttle feed through

The tubing we have for building the throttle feed through is SMLS CD304/L A269 1-1/2 X .035 WA Stainless steel tubing \$23.74/ft, extended price for 20 feet \$474.80 cost

Colin Gould  
Structures Manager  
Eagle Copters Maintenance Ltd  
[cgould@eaglecopters.com](mailto:cgould@eaglecopters.com)

10/14/09